

Date: Tuesday, 24/06/2008 2:17:54 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MIRROR ARM	
Job Number	: 40046		Part Number	: D2010104	
Estimate Number	: 10335		Drawing Number	: D2010 REV D	
P.O. Number	:		Project Number	: N/A	
This Issue	24/06/2008	S.O. No.	Drawing Revision	: D	
Prsht Rev.	: NC		Material	:	
First Issue	1 /	Type	Due Date	75	Qty: 00 Um: Each
Previous Run	: 39823		27/06/2008		
Written By	:				
Checked & Approved By	: JUL 08.16.24				
Comment	: Est A 04.02.17 New issue KJ/JLM Est Rev:B 08-05-27 as per ECN1195P DD verified by:EC Est Rev:C 08-06-20 rev.D as per dwg DD verified by:EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W049	304 RD Tube .500 x .049W	
<b>Comment:</b> Qty.: 1.5750 f(s)/Unit Total : 94.5000 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall (M304TR0500W049) Batch No: M108324			
2.0	BRAKE NC	NC BRAKE	
<b>Comment:</b> BRAKE NC Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- Deburr ends			
4.0	D2057	Plug	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s) Plug batch: B39826 (x17) / B40048 (x58)			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 2:17:54 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 40046

Part Number: D2010104

Job Number:



Seq. #: Machine Or Operation:

Description :

2- Install D2057 plug as per Dwg D2010

PF 08-06-27

75

6.0 QC5

INSPECT WORK TO CURRENT STEP



*27/06/08*



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



m162316



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

1<sup>st</sup> rack

START TIME:

8:40

2<sup>nd</sup> rack

start time 8:55

3<sup>rd</sup> rack

start time 9:10

08/07/01

OVEN TEMPERATURE:

320

oven temp 320

oven temp 320

FINISH TIME:

9:10

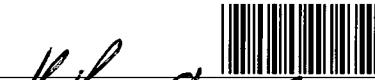
Finish time 9:23

Finish time 9:46

08/07/01

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



75

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*PL 08-07-01 (75)*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CMF 08-07-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

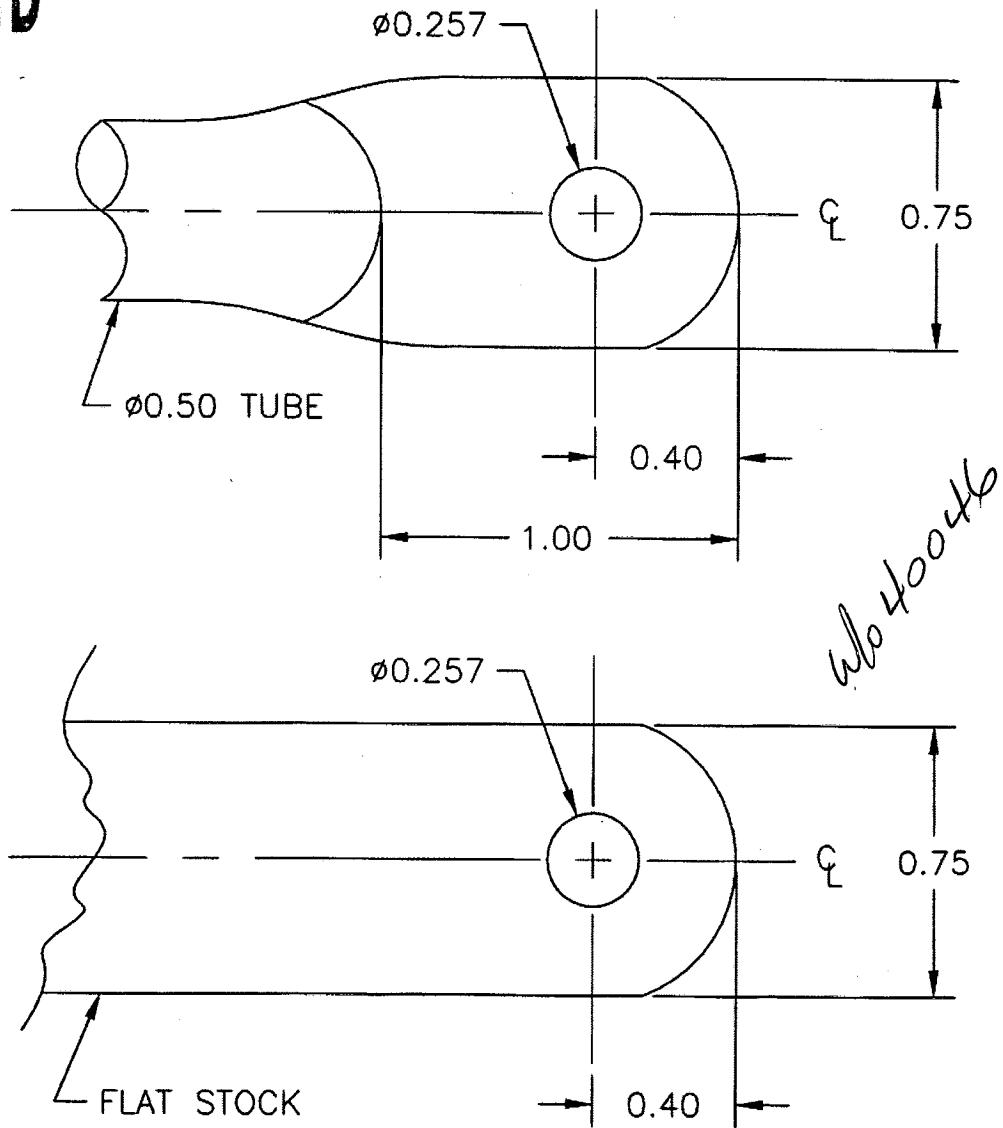
**DART**

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DMY</i>	APPROVED <i>CF</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING  
FOR PUNCH DT8012

**RELEASED**

98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

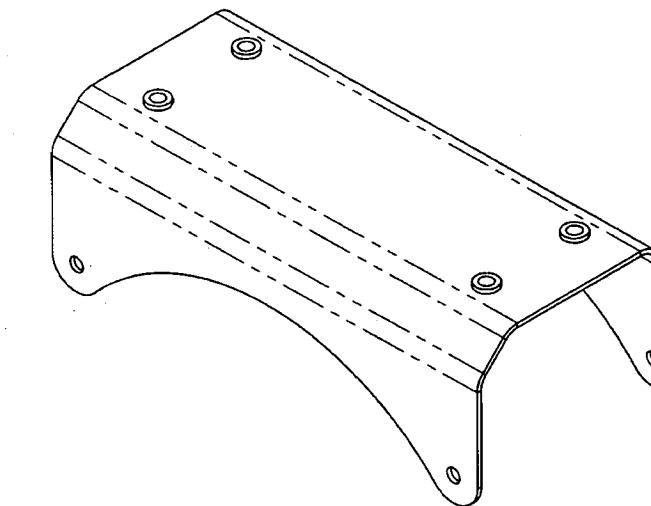
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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

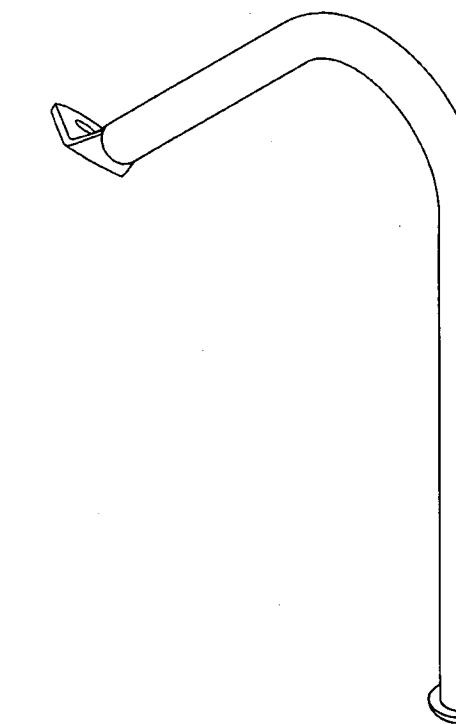
NOTE: Date & initial all entries

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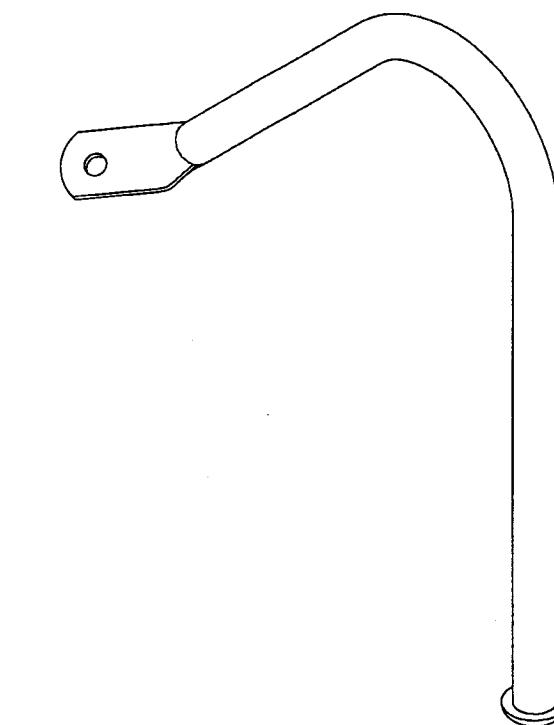
D



D2010-101 MIRROR BRACKET



D2010-103 ARM



D2010-104 ARM

D

C

B

A

A

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WORK ORDER  
NO. 40040

**RELEASED**  
*13-06-14/WP*

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON; TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION		BY DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PJ		
CHECKED			
MFG. APPR.		DRAWING NO.	D2010
APPROVED		REV. D	SHEET 1 OF 4
DE APPR.		TITLE	MIRROR BRACKET
DATE	08.06.10	SCALE	NTS

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8

7

6

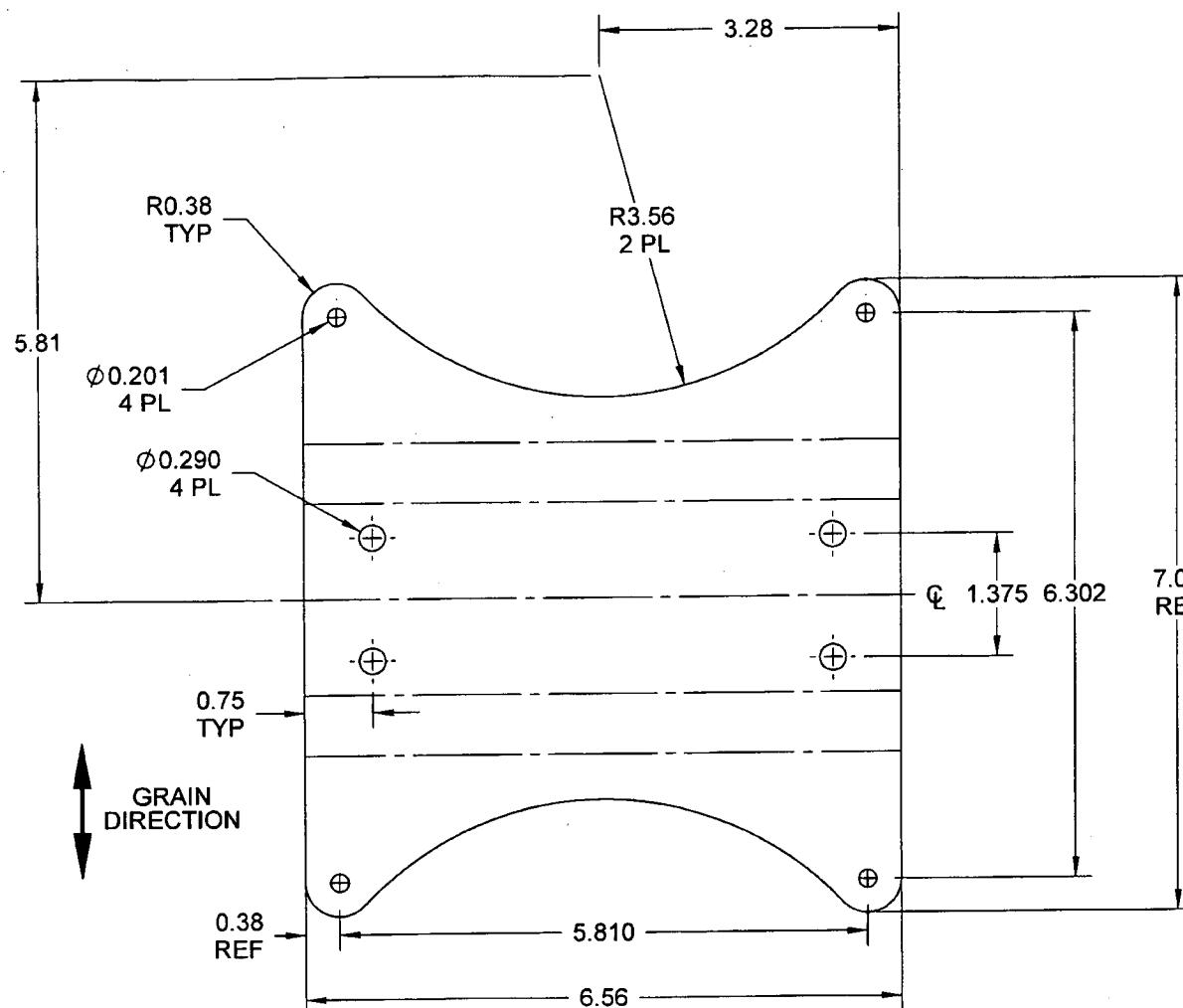
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4

3

2

1

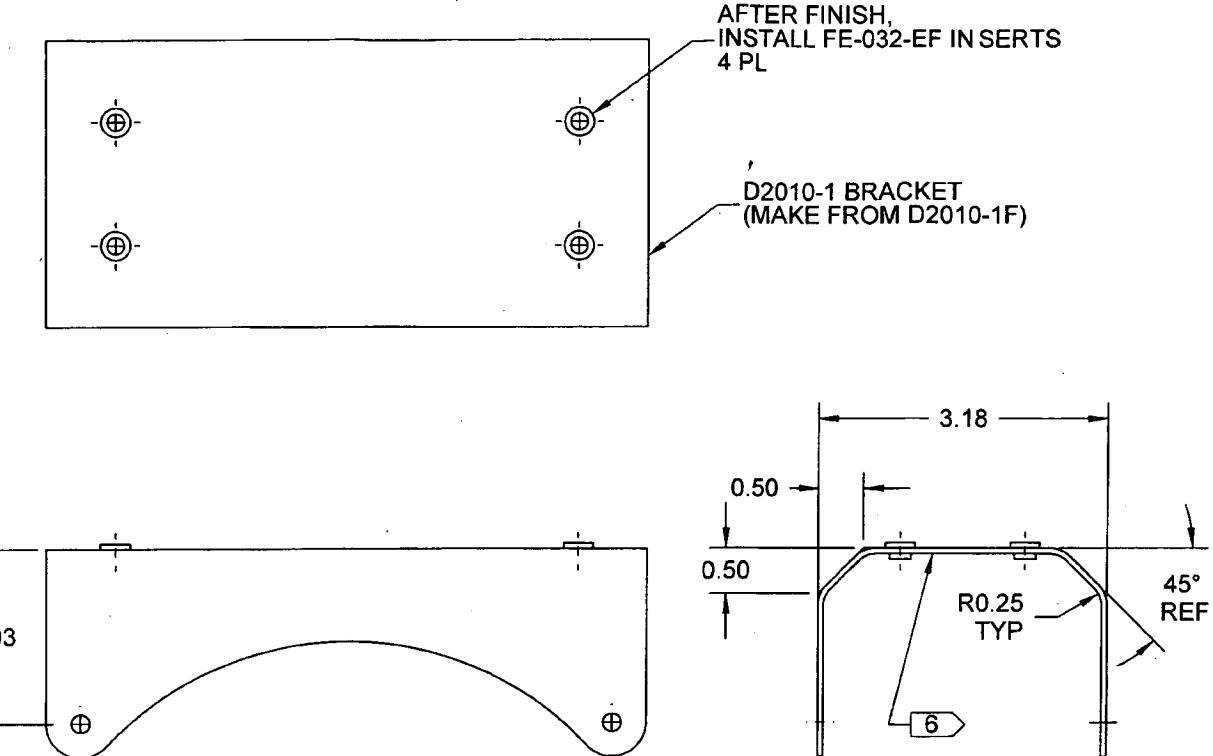


D2010-1F FLAT PATTERN

**NOTES:**

- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR A (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERM
- 7) WEIGHT: 0.23 lbs

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



## D2010-101 MIRROR BRACKET

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40096

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DRAWN	PSL	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2010	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
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8

7

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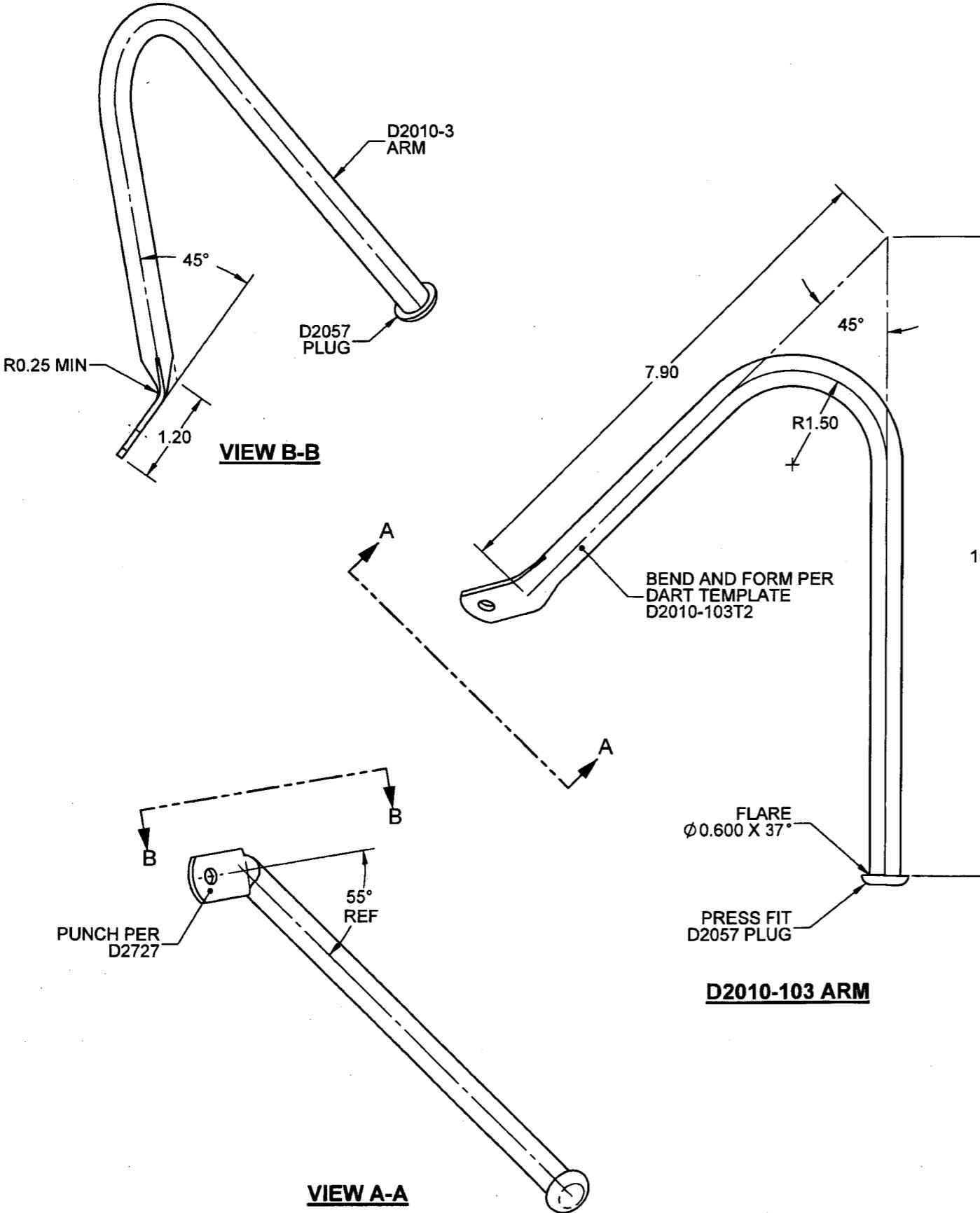
5

4

3

2

1



QTY	P/N	DESCRIPTION
-103		
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG

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08.06.10

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NO. 40016

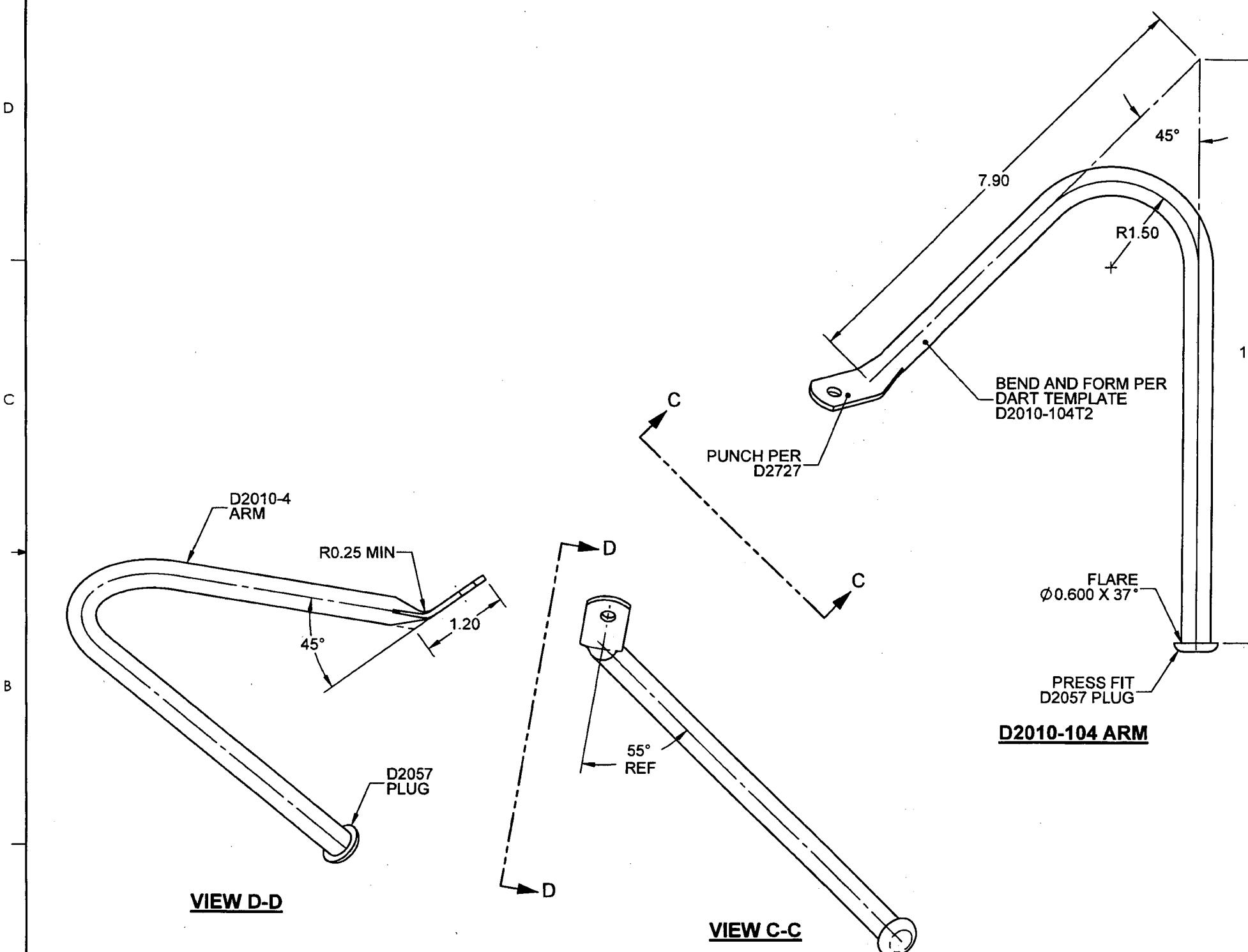
**NOTES:**

- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING Ø0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049) **D** SUBJECT TO AMENDMENT
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JB	<b>DART AEROSPACE LTD</b>
DRAWN	<b>8</b>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<b>PH</b>	DRAWING NO.
MFG. APPR.	<b>PH</b>	<b>D2010</b>
APPROVED	<b>PH</b>	REV. D
DE APPR.	<b>PH</b>	SHEET 3 OF 4
DATE	<b>08.06.10</b>	TITLE
		SCALE
		NTS
		<b>MIRROR BRACKET</b>
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8 7 6 5 4 3 2 1

DESCRIPTION	
QTY	P/N
-104	
X	D2010-104
1	D2010-4
1	D2057
	PLUG



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08-06-10

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NO. 40046

NOTES:

- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING Ø0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049) **D** SUBJECT TO AMENDMENT
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JB	<b>DART AEROSPACE LTD</b>
DRAWN	<b>B</b>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<b>PH</b>	DRAWING NO.
MFG. APPR.	<b>PH</b>	<b>D2010</b>
APPROVED	<b>PH</b>	REV. D
DE APPR.	<b>PH</b>	SHEET 4 OF 4
DATE	<b>08.06.10</b>	SCALE
		NTS
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